

SPECIAL PACKAGING INSTRUCTION

Form Approved -SS RJ
OMB No. 0704-0188

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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE 57K1224 (19207) KIT, MG RING MOUNTING			2. CODE INDENT 19207		3. SPI NO. AK13815431	
4. NATIONAL STOCK NO. 1005-01-381-5431			5. DATE OF DRAWING 05-31-2002		6. REVISION B	
7. QUP 1 EACH	8. ICQ NONE	9. UNIT PACK WT. (LB) 268.0	10. UNIT PACK CU (CU. FT.) 23.366	11. UNIT PACK SIZE (INCHES) 42.3 X 31.5 X 30.3		
12. MILITARY PRESERVATION METHOD 10 13. CLEANING MIL-STD-2073-1D, PROCEDURE 1 14. DRYING MIL-STD-2073-1D 15. PACKING a. LEVEL A MIL-STD-2073-1D AND NOTE M b. LEVEL B NOT APPLICABLE 16. MARKING MIL-STD-129 AND NOTE L			18.	19.	20.	
			STEPS	REQD	DESCRIPTION	
			1L		CUSHIONING, BLOCKING, AND BRACING: SEE NOTES.	
			2L	1	CONTAINER: PPP-B-601, STYLE A, TYPE O,	
					SIZE 40 X 29-1/4 X 25. SEE NOTES.	
			3L		CLOSURE: SEE NOTES.	

17. NOTES/DRAWING

A. QUALITY ASSURANCE PROVISIONS:

INSPECT THE PRESERVATION AND UNIT PACK IN ACCORDANCE WITH MIL-STD-2073-1D. INSPECT PACKING IN ACCORDANCE WITH MIL-STD-2073-1D AND THE APPLICABLE CONTAINER SPECIFICATION.

B. THE KIT CONSISTS OF:

Segregated Pack Number (SPN)	Part Number	Item Description	Item Qty.
1		CONSOLIDATION CONTAINER FOR 1A THROUGH 1V.	1
1A	12414419-076	SCREW, HEX HEAD	10
1B	12414419-079	SCREW, HEX HEAD	6
1C	12414419-093	SCREW, HEX HEAD	4
1D	12414419-136	SCREW, HEX HEAD	12
1E	12414473-011	WASHER, PLAIN	10
1F	12414473-013	WASHER, PLAIN	4
1G	12414473-015	WASHER, PLAIN	12
1H	12414582-004	WASHER, HEAVY	4
1J	12417948-005	WASHER, FLAT	12
1K	12419169-005	NUT, PLAIN, CLINCH	10
1L	12420196-001	LANYARD ASSEMBLY	2
1M	12420482	PIN, HINGE	2
1N	12420483	BRACKET, MOUNTING	2
1P	12420484	BRACKET, MOUNTING	2
1Q	MS17987-630	PIN, QUICK RELEASE	2
1R	MS24665-385	PIN, COTTER	4

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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE

57K1224 (19207) KIT, MG RING MOUNTING

2. CODE INDENT

19207

3. SPI NO.

AK13815431

4. NATIONAL STOCK NO.

1005-01-381-5431

5. DATE OF DRAWING

05-31-2002

6. REVISION

B

Segregated Pack Number (SPN)	Part Number	Item Qty.	Item Description
1S	12414419-080	4	SCREW, HEX HEAD
1T	12414419-096	4	SCREW, HEX HEAD
1U	12422890	4	SHIM
1V	12422891	2	SHIM
2	12414321-003	1	SEAT, VEHICULAR, CENTER
3	12417568	1	SHORE WELD ASSEMBLY
4	12418327	1	GASKET, ROUND
5	12418362-004	1	PLATFORM ASSEMBLY, MG
6	12418366-012	1	FRAME ASSEMBLY, FLOOR, BODY, VEHICULAR
7		1	CONSOLIDATION CONTAINER FOR SPN 7A AND 7B
7A	12378587	1	MOUNT, MG RING - INSTALLATION DWG
7B	12420514	1	COVER, DEFROSTER, REWORK INSTRUCTION

C. PREPARE SEGREGATED PACK NUMBERS 1A THROUGH 1V IN ACCORDANCE WITH THE FOLLOWING STEPS.**PREPARE SPN 1A, SCREW, HEX HEAD, 12414419-076, 10 EACH AS FOLLOWS.**

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "SEGREGATED PACK NUMBER 1A" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1B, SCREW, HEX HEAD, 12414419-079, 6 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "SEGREGATED PACK NUMBER 1B" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1C, SCREW, HEX HEAD, 12414419-093, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "SEGREGATED PACK NUMBER 1C" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1D, SCREW, HEX HEAD, 12414419-136, 12 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "SEGREGATED PACK NUMBER 1D" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

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PREPARE SPN 1E, WASHER, PLAIN, 12414473-011, 10 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1E**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1F, WASHER, PLAIN, 12414473-013, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1F**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1G, WASHER, PLAIN, 12414473-015, 12 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1G**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1H, WASHER, HEAVY, 12414582-004, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1H**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1J, WASHER, FLAT, 12417948-005, 12 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1J**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1K, NUT, PLAIN CLINCH 12419169-005, 10 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1K**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1L, LANYARD, ASSEMBLY, 12420196-001, 2 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 10 X 17, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1L**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

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PREPARE SPN 1M, PIN, HINGE 12420482, 2 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1M**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1N, BRACKET, MOUNTING, 12420483, 2 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1N**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1P, BRACKET, MOUNTING, 12420484, 2 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1P**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1Q, PIN, QUICK RELEASE, MS17987-630, 2 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1Q**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1R, PIN, COTTER, MS24665-385, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1R**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1S, SCREW, HEX HEAD, 12414419-080, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1S**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1T, SCREW, HEX HEAD, 12414419-096, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 8, (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1T**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

PREPARE SPN 1U, SHIM, 12422890, 4 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 8 X 10 (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1U**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

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PREPARE SPN 1V, SHIM, 12422891, 2 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 6 X 6 (QTY. 1).
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 1V**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

D. SEGREGATED PACK NUMBERS 1A THROUGH 1V ARE CONSOLIDATED WITHIN SPN 1 IN ACCORDANCE WITH THE FOLLOWING STEPS:

1. **CONTAINER:** ASTM D5118, STYLE RSC, TYPE CF, GRADE V3c, CLASS WR, SIZE 16-3/4 X 9-1/2 X 5-3/4, (QTY. 1). PLACE PREPARED ITEMS INTO CONTAINER.
2. **CUSHIONING:** PPP-C-1797, TYPE I, 1/4" THICK, SIZE 60 X 24, (1 PIECE). FOLD TO 16 X 9 AND PLACE OVER PREPARED ITEMS.
3. **CLOSURE:** THE WR CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, SEALING METHOD B OR C.
4. **IDENTIFICATION:** IDENTIFY THE CONTAINER WITH "**SEGREGATED PACK NUMBER 1**" IN ACCORDANCE WITH MIL-STD-129.
5. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 10**.

E. PREPARATION OF SEGREGATED PACK NUMBER 2.

PREPARE SEAT, VEHICULAR, CENTER, 12414321-003, 1 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **CUSHIONING, BLOCKING AND BRACING:**
 - a. FABRICATE CUSHIONING, BLOCKING, AND BRACING IN ACCORDANCE WITH THE CHART AND SKETCHES SHOWN ON PAGE 5.
 - b. WRAP SEAT CUSHIONS WITH CUSHIONING WRAP "A" AND CUSHIONING WRAP "B" AS SHOWN IN SKETCH ON PAGE 6 AND SECURE USING A-A-883, TYPE II TAPE.
 - c. SECURE PAD "D" TO SLEEVE "C" AS SHOWN IN SKETCH ON PAGE 5 USING A SUITABLE WATERPROOF GLUE.
 - d. PLACE SLEEVE "C" AND PAD "E" AS SHOWN IN SKETCH ON PAGE 6.
3. **CONTAINER:** ASTM D5118, STYLE RSC, TYPE CF, GRADE 275, CLASS DOM, SIZE 21-5/8 X 13-1/8 X 25-3/8, (QTY. 1).
4. **CLOSURE:** THE DOM CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, CLOSURE METHOD 2B6. A-A-883, TYPE II TAPE MAY BE USED INSTEAD OF TAPE SPECIFIED IN REQUIRED METHOD.
5. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 40 X 50, (QTY. 1).
6. **CONTAINER:** ASTM D5118, STYLE RSC, TYPE CF, GRADE V3c, CLASS WR, SIZE 22-3/8 X 13-7/8 X 26-5/8, (QTY. 1).
7. **CLOSURE:** THE WR CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, SEALING METHOD B OR C.
8. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 2**" IN ACCORDANCE WITH MIL-STD-129.
9. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 32**.

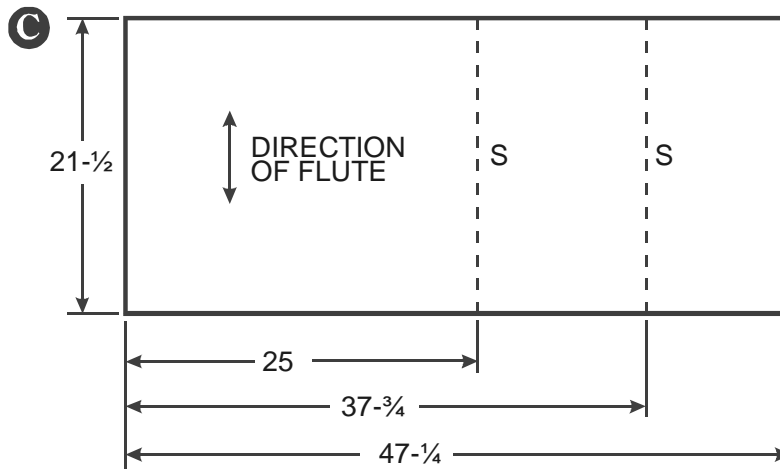
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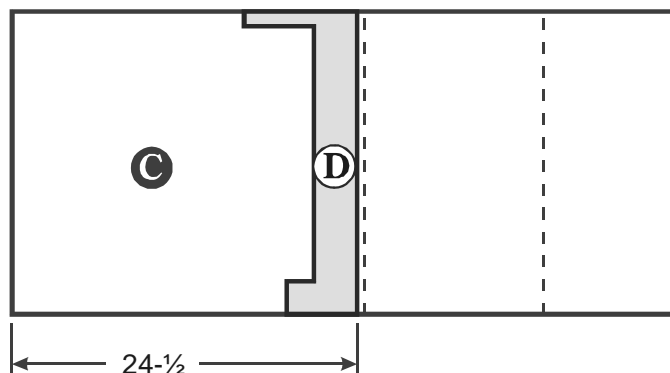
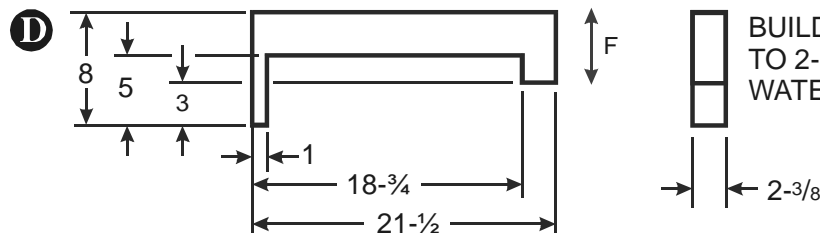
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Pad or Block Number	PPP-F-320, Type CF, (Grade, Class, Variety)	PPP-C-1797, Type I, 1/4" Thick CUSHIONING WRAP	Critical Dimensions (Inches) L W D			Qty	Comments
A		60 X 24				1	
B		24 X 24				1	
C	DOM, TW					1	SEE SKETCH BELOW.
D	DOM					1	SEE SKETCH BELOW.
E	DOM		21-1/2	6	1-3/4	1	



All dimensions are in inches.
All dimensions are actual.
S represents score line.
F represents the flutes.



ASSEMBLE PAD "D" AND SLEEVE "C" USING A SUITABLE WATERPROOF GLUE.

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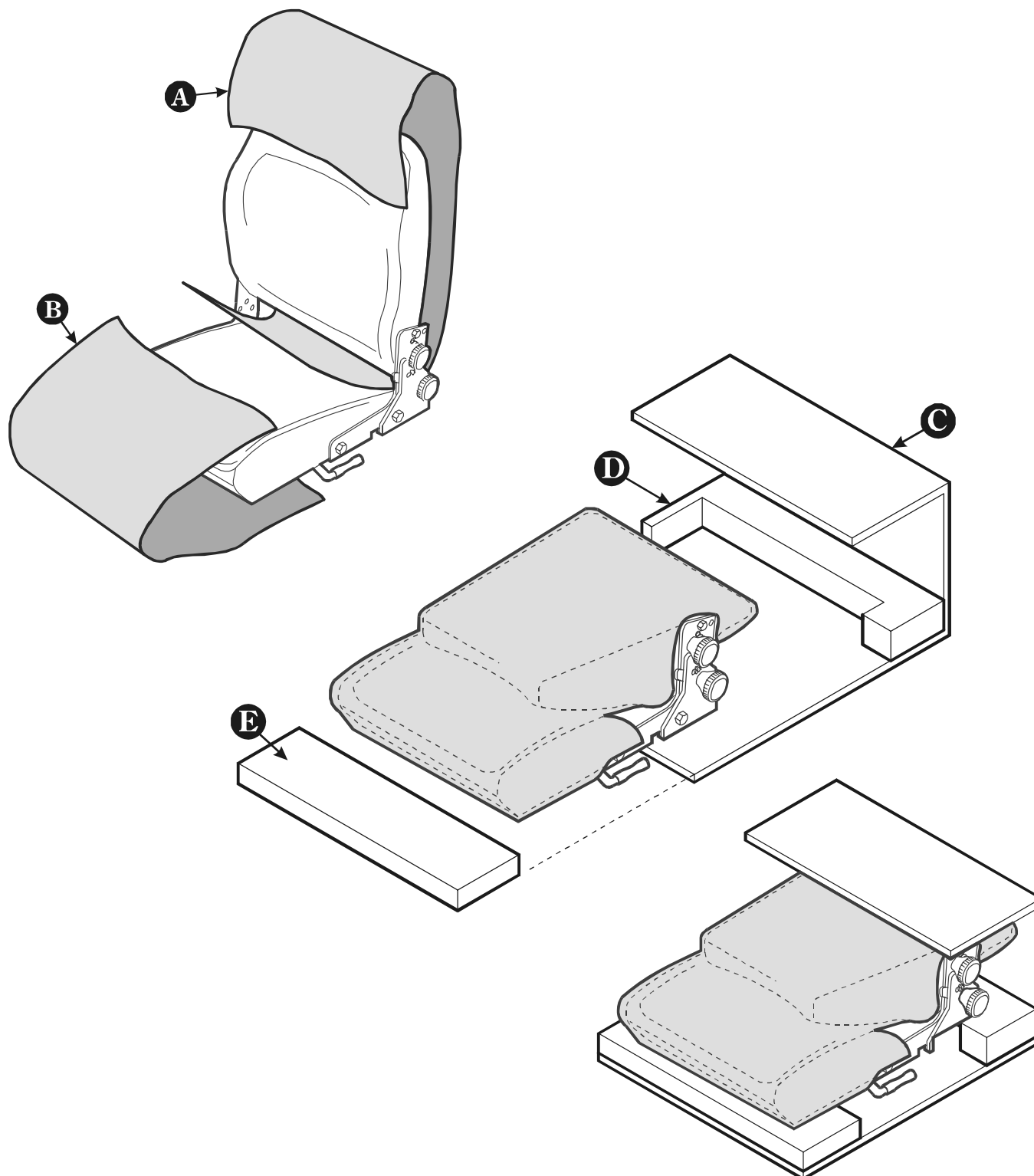
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F. PREPARATION OF SEGREGATED PACK NUMBER 3.

PREPARE SHORE WELD ASSEMBLY, 12417568, 1 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE
2. **WRAP:** MIL-B-121, TYPE II, GRADE A, CLASS 2, SIZE 36 X 12, (1 PIECE). SECURE WRAP USING PPP-T-60, TYPE III, CLASS 1 TAPE.
3. **CUSHIONING WRAP:** PPP-P-291, SIZE 36 X 12, (1 PIECE). SECURE CUSHIONING WRAP USING PPP-T-60, TYPE III, CLASS 1 TAPE.
4. **CONTAINER:** ASTM D5118, STYLE OPF, TYPE CF, GRADE V3c, CLASS WR, SIZE 31-1/4 X 4-5/8 X 1-5/8, (QTY. 1).
5. **CLOSURE:** THE WR CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, SEALING METHOD B OR C.
6. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 3**" IN ACCORDANCE WITH MIL-STD-129.
7. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 10**.

G. PREPARATION OF SEGREGATED PACK NUMBER 4.

PREPARE GASKET, ROUND, 12418327, 1 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE
2. **NOTE:** COIL GASKET TO APPROXIMATELY 16" DIAMETER AND PLACE INTO CONTAINER.
3. **CONTAINER:** ASTM D5118, STYLE RSC, TYPE CF, GRADE 275, CLASS DOM, SIZE 16 X 16 X 4-1/2, (QTY. 1).
4. **CLOSURE:** THE DOM CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, CLOSURE METHOD 2B6. A-A-883, TYPE II TAPE MAY BE USED INSTEAD OF TAPE SPECIFIED IN REQUIRED METHOD.
5. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 23 X 29, (QTY. 1).
6. **CONTAINER:** ASTM D5118, STYLE RSC, TYPE CF, GRADE V3c, CLASS WR, SIZE 16-3/4 X 16-3/4 X 5-3/4, (QTY. 1).
7. **CLOSURE:** THE WR CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, SEALING METHOD B OR C.
8. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 4**" IN ACCORDANCE WITH MIL-STD-129.
9. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 32**.

H. PREPARATION OF SEGREGATED PACK NUMBER 5.

PREPARE PLATFORM ASSY, MG, 12418362-004, 1 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **WRAP:** MIL-B-121, TYPE II, GRADE A, CLASS 2, SIZE 72 X 36, (1 PIECE). SECURE WRAP USING A-A-883, TYPE II TAPE.
3. **CUSHIONING, BLOCKING AND BRACING:** MIL-STD-1186.
 - a. FABRICATE CUSHIONING, BLOCKING, AND BRACING IN ACCORDANCE WITH CHART AND SKETCHES SHOWN ON PAGE 8.
 - b. PLACE PADS "F" AND PADS "G" AS SHOWN IN SKETCH ON PAGE 9 AND SECURE USING A-A-883, TYPE II TAPE.
4. **CONTAINER:** ASTM D5118, STYLE OPF, TYPE CF, GRADE 275, CLASS DOM, SIZE 35-3/8 X 27-1/2 X 2-1/2, (QTY. 1).
5. **CLOSURE:** THE DOM CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, CLOSURE METHOD 2B6. A-A-883, TYPE II TAPE MAY BE USED INSTEAD OF TAPE SPECIFIED IN REQUIRED METHOD.
6. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 32 X 46, (QTY. 1).
7. **CONTAINER:** ASTM D5118, STYLE OPF, TYPE CF, GRADE V3c, CLASS WR, SIZE 36-1/8 X 28-1/8 X 3-3/8, (QTY. 1).
8. **CLOSURE:** THE WR CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, SEALING METHOD B OR C.
9. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 5**" IN ACCORDANCE WITH MIL-STD-129.
10. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 32**.

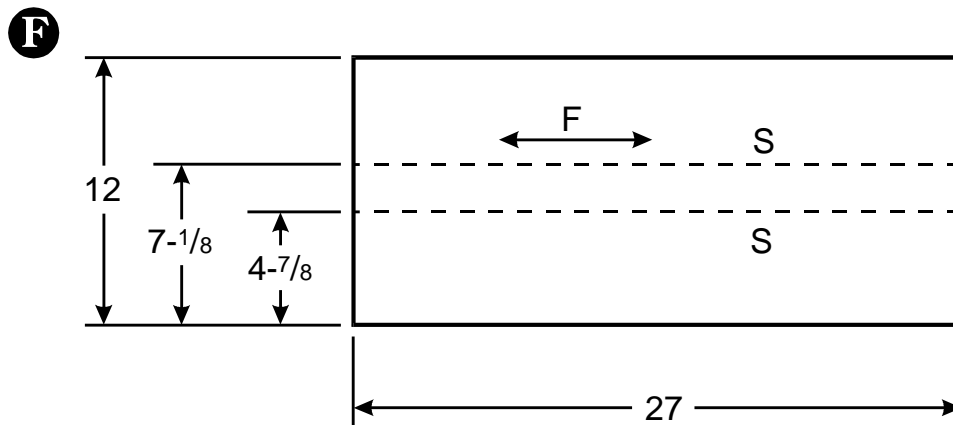
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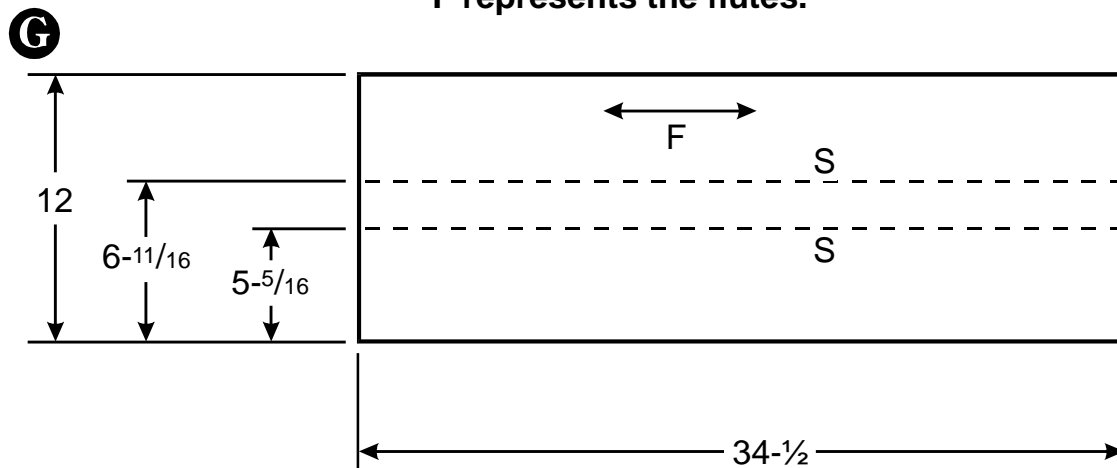
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1. PART OR DRAWING NO. (CAGE) NOMENCLATURE 57K1224 (19207) KIT, MG RING MOUNTING	2. CODE INDENT 19207	3. SPI NO. AK13815431
4. NATIONAL STOCK NO. 1005-01-381-5431	5. DATE OF DRAWING 05-31-2002	6. REVISION B

Pad or Block Number	PPP-F-320, Type CF, (Grade, Class, Variety)	Critical Dimensions (Inches)			Qty	Comments
		L	W	D		
F	DOM, DW				2	SEE SKETCH BELOW.
G	DOM, DW				2	SEE SKETCH BELOW.



All dimensions are in inches.
All dimensions are actual.
S represents score line.
F represents the flutes.

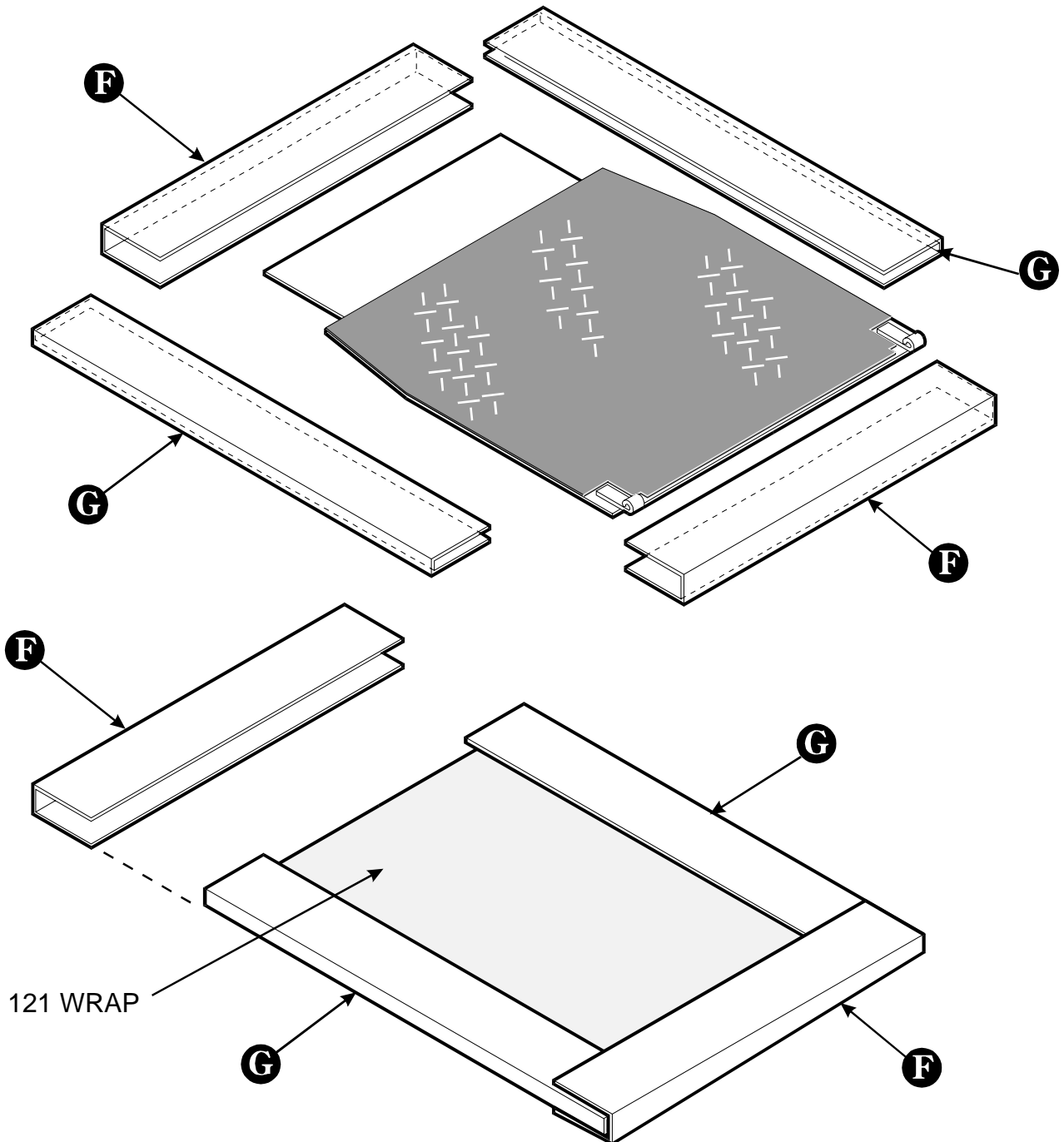


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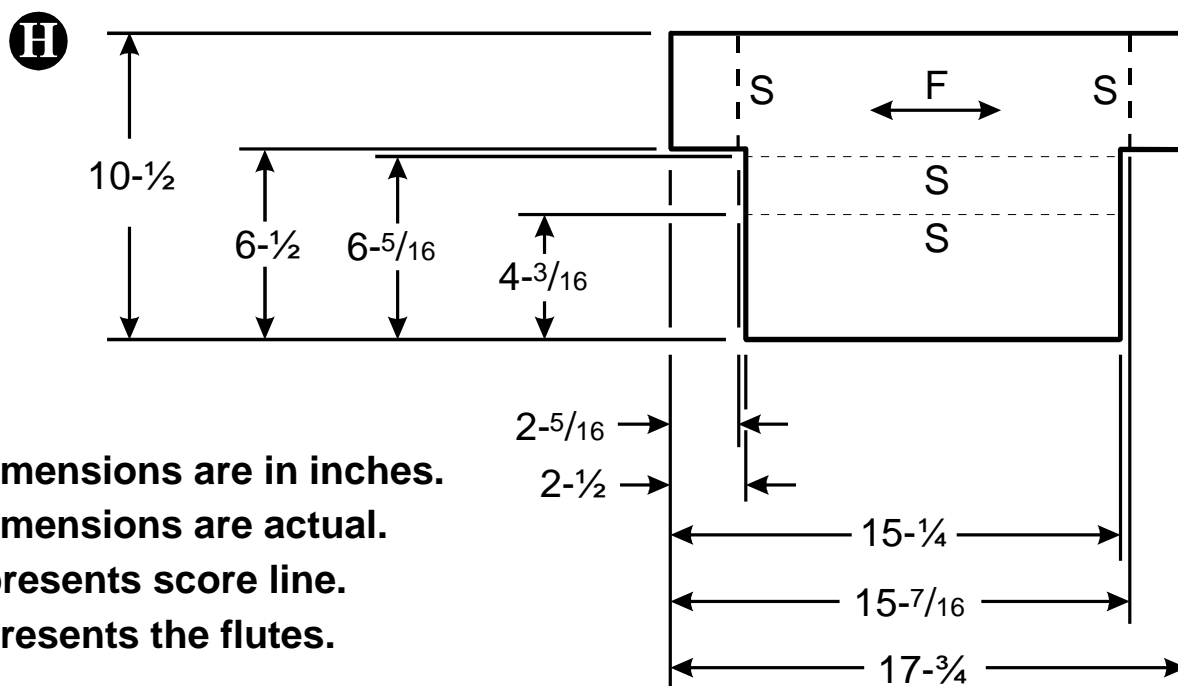
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PREPARE FRAME ASSY, FLOOR, BODY, VEHICULAR, 12418366-012, 1 EACH AS FOLLOWS.

1. **PRESERVATIVE:** NONE.
2. **CUSHIONING, BLOCKING AND BRACING:** MIL-STD-1186.
 - a. FABRICATE CUSHIONING, BLOCKING, AND BRACING IN ACCORDANCE WITH THE CHART AND SKETCHES SHOWN BELOW.
 - b. SECURE CUSHIONING WRAPS "J" AND CUSHIONING WRAP "K" AS SHOWN IN SKETCH ON PAGE 11 USING A-A-883, TYPE II TAPE.
 - c. FOLD PADS "H" AS SHOWN IN SKETCH ON PAGE 11 AND SECURE USING A-A-883, TYPE II TAPE. PLACE PADS "H" AS SHOWN IN SKETCH ON PAGE 11.
3. **CONTAINER:** ASTM D5118, STYLE FOL, TYPE CF, GRADE 275, CLASS DOM, SIZE 13-1/2 X 3-1/8 X 29-3/4, (QTY. 1).
4. **CLOSURE:** THE DOM CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, CLOSURE METHOD 4B2. A-A-883, TYPE II TAPE MAY BE USED INSTEAD OF TAPE SPECIFIED IN REQUIRED METHOD.
5. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 18 X 40, (QTY. 1).
6. **CONTAINER:** ASTM D5118, STYLE FOL, TYPE CF, GRADE V3c, CLASS WR, SIZE 14-1/8 X 3-3/4 X 31-3/8, (QTY. 1).
7. **CLOSURE:** THE WR CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH ASTM D 1974, SEALING METHOD B OR C.
8. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 6**" IN ACCORDANCE WITH MIL-STD-129.
9. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD IC-2**.

Pad or Block Number	PPP-F-320, Type CF, (Grade, Class, Variety)	PPP-P-291, Cushioning Wrap	Critical Dimensions (Inches)			Qty	Comments
			L	W	D		
H	DOM, DW					2	SEE SKETCH BELOW.
J		32 X 8				2	
K		24 X 12				1	



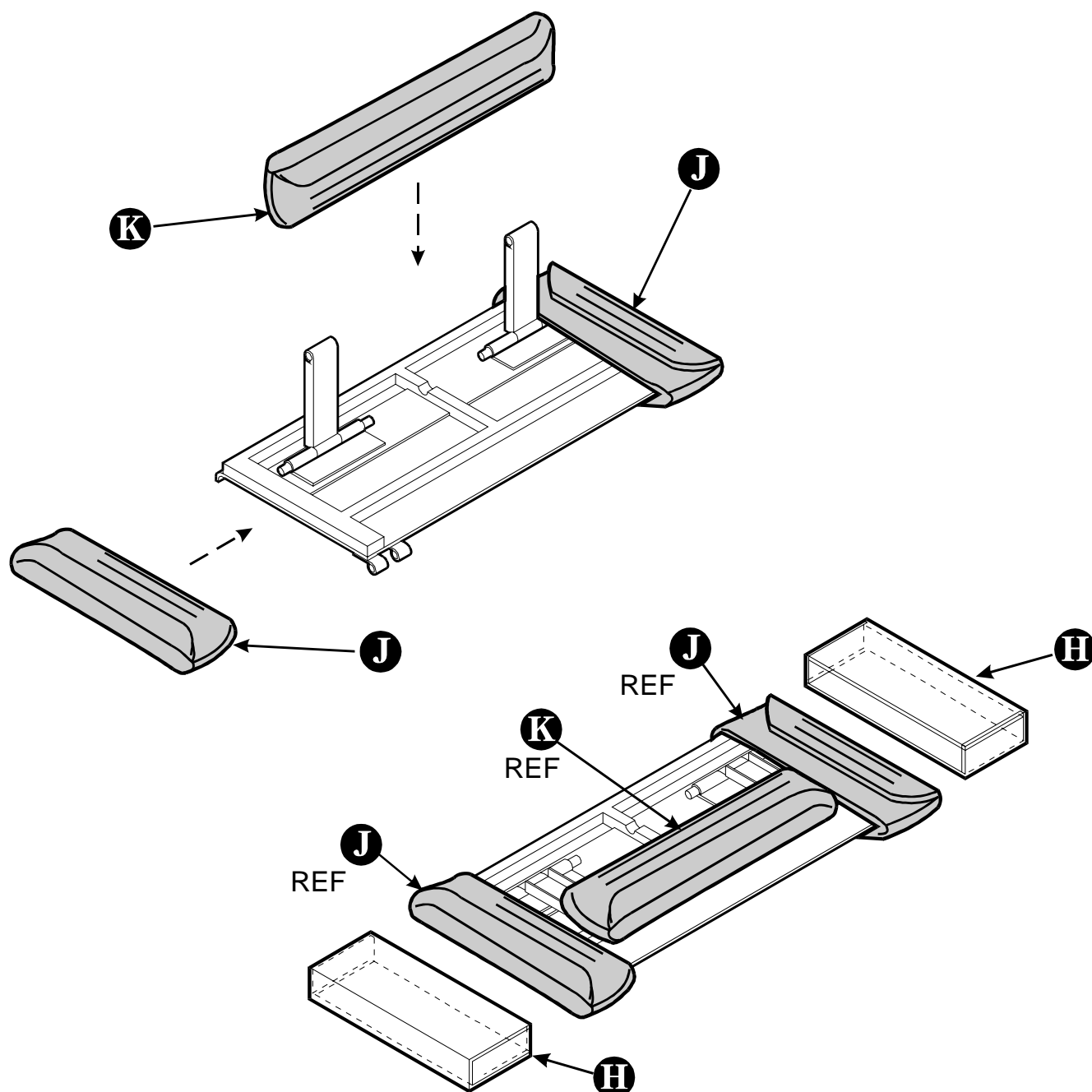
All dimensions are in inches.
All dimensions are actual.
S represents score line.
F represents the flutes.

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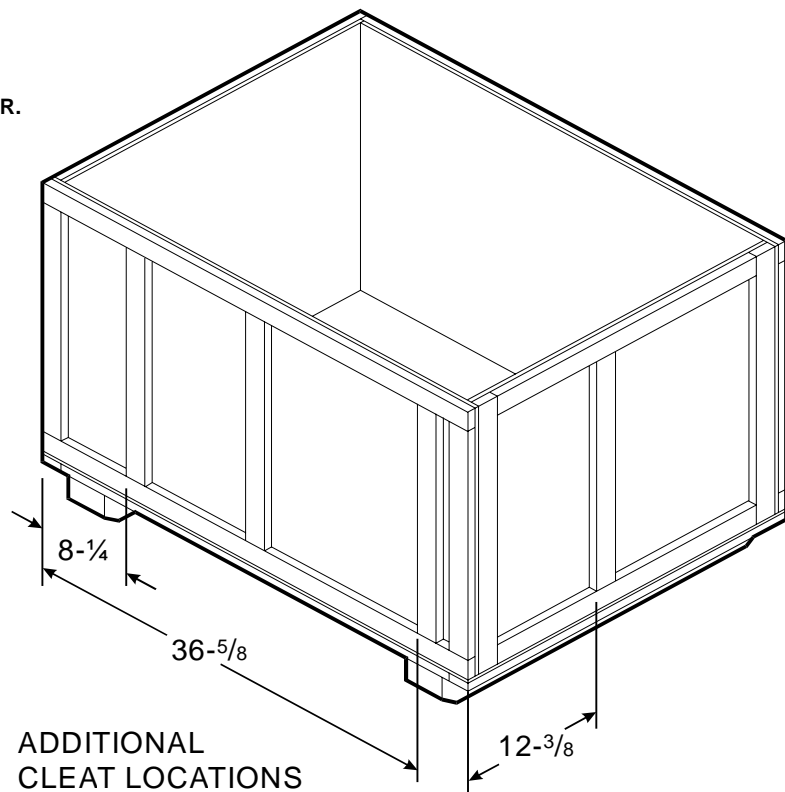
K. PREPARE SPN 7A, 12378587, MOUNT, MG RING - INSTALLATION (DRAWING), 1 EACH AND SPN 7B, 12420514, COVER, DEFROSTER, REWORK INSTRUCTION, 1 EACH AS FOLLOWS:

1. **PRESERVATIVE:** NONE.
2. **BAG:** MIL-B-117, STYLE 1, TYPE I, CLASS C, SIZE 10 X 16, (QTY. 1).
 - a. PLACE BOTH SPN 7A AND SPN 7B INTO BAG AND HEAT SEAL CLOSE.
3. **IDENTIFICATION:** IDENTIFY THE UNIT PACK WITH "**SEGREGATED PACK NUMBER 7**" IN ACCORDANCE WITH MIL-STD-129.
4. **INSPECTION:** INSPECT THE SEGREGATED PACK IN ACCORDANCE WITH THE CRITERIA FOR **METHOD 31**.

L. CONSOLIDATE AND CONTAINERIZE SEGREGATED PACK NUMBERS 1, 2, 3, 4, 5, 6 AND 7 IN ACCORDANCE WITH THE FOLLOWING STEPS:

1. **PRESERVATIVE:** NONE.
2. **CONTAINER:** FABRICATE THE CONTAINER IN ACCORDANCE WITH BLOCKS 18, 19, AND 20 SHOWN ON PAGE 1.
 - a. SKIDS SHALL BE BEVELED IN ACCORDANCE WITH THE CONTAINER SPECIFICATIONS.
 - b. PLACE ADDITIONAL 1-3/4" WIDE CLEATS (3 EACH) AT LOCATIONS SHOWN IN SKETCH BELOW.
3. **CUSHIONING, BLOCKING, AND BRACING:** MIL-STD-1186.
 - a. FABRICATE CUSHIONING, BLOCKING, AND BRACING IN ACCORDANCE WITH THE CHART SHOWN ON PAGE 13.
 - b. SECURE **BLOCKS "L"** AND **"M"** AS SHOWN IN SKETCH ON PAGE 13 USING STAPLES CONFORMING TO FF-N-105.
 - c. PLACE **SEGREGATED PACK NUMBERS 1, 2, 3, 4, 5, 6** AND **DUMMY BOXES "N", "P",** AND **"Q"** AS SHOWN IN SKETCH ON PAGES 14 AND 15.
 - d. SECURE **SEGREGATED PACK NUMBER 7** TO **SEGREGATED PACK NUMBER 5** AS SHOWN ON PAGE 15 USING PPP-T-60 TYPE III, CLASS 1 TAPE.
4. **CLOSURE:** THE CONTAINER SHALL BE CLOSED IN ACCORDANCE WITH PPP-B-601.
5. **IDENTIFICATION:** PROVIDE PACKING LIST WITH THE CONSOLIDATED PACK IN ACCORDANCE WITH MIL-STD-129. ON THE PACKING LIST IDENTIFY THE ITEMS WITHIN EACH SEGREGATED PACK TOGETHER WITH THEIR SEGREGATED PACK NUMBER.
6. **INSPECTION:** INSPECT THE CONSOLIDATED PACK IN ACCORDANCE WITH MIL-P-116, **METHOD 10**.

M. THE UNIT CONTAINER IS THE SHIPPING CONTAINER.



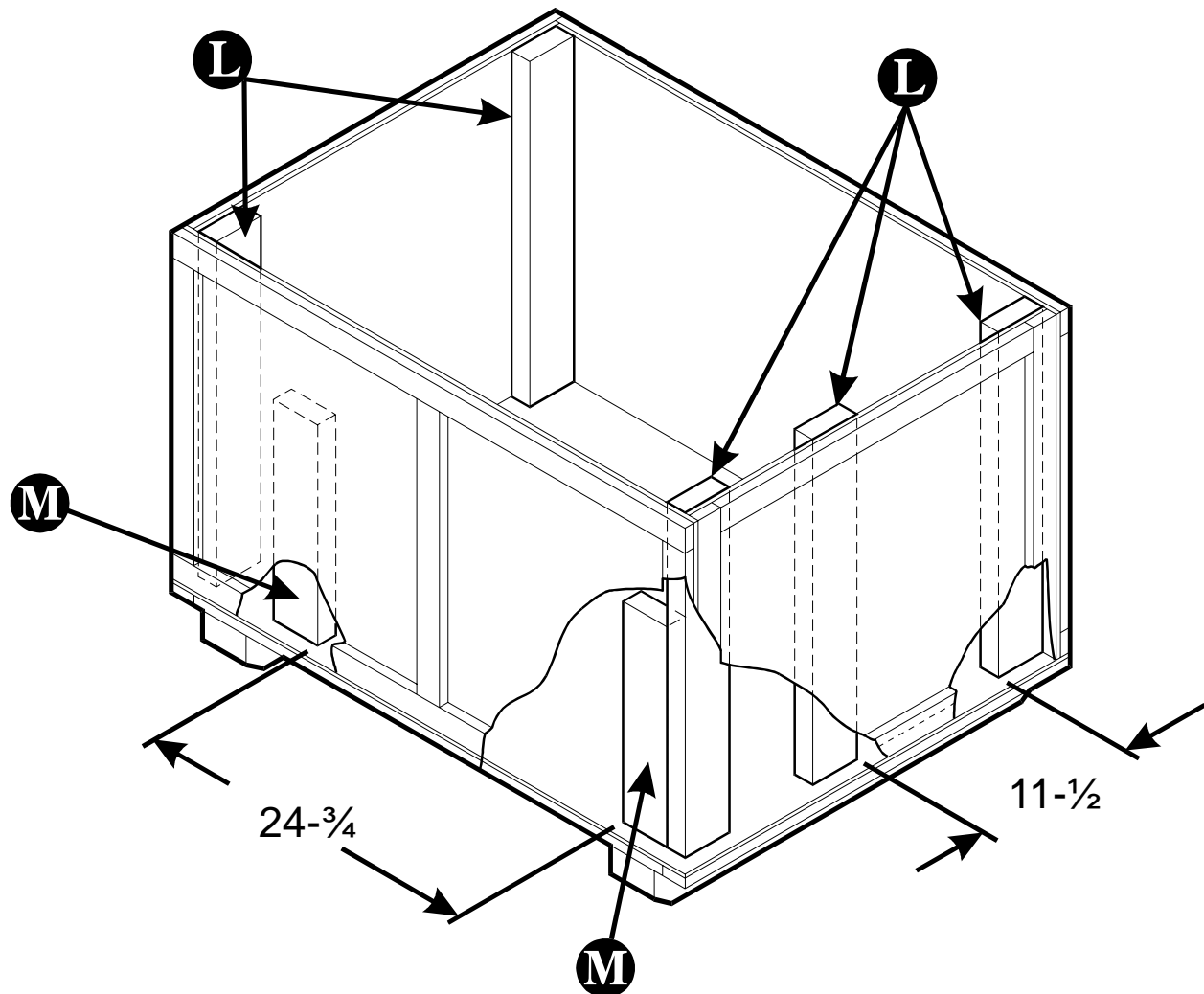
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Pad or Block Number	MIL-STD-731, Lumber (Nominal Size)	ASTM D5118 Dummy Boxes Style RSC, Type CF, Grade V3c, Class WR	Critical Dimensions (Inches)			Qty	Comments
L	2 X 4		L	W	D		
L	2 X 4		24-3/8			5	
M	2 X 4		15-1/2			2	
N		SEE DIMENSIONS	19-3/8	10-5/8	19-7/8	1	(CONTAINER INSIDE DIMENSIONS)
P		SEE DIMENSIONS	5-1/4	3-7/8	19-1/2	1	(CONTAINER INSIDE DIMENSIONS)
Q		SEE DIMENSIONS	9-1/4	6	26-1/2	1	(CONTAINER INSIDE DIMENSIONS)



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57K1224 (19207) KIT, MG RING MOUNTING

2. CODE INDENT

19207

3. SPI NO.

AK13815431

4. NATIONAL STOCK NO.

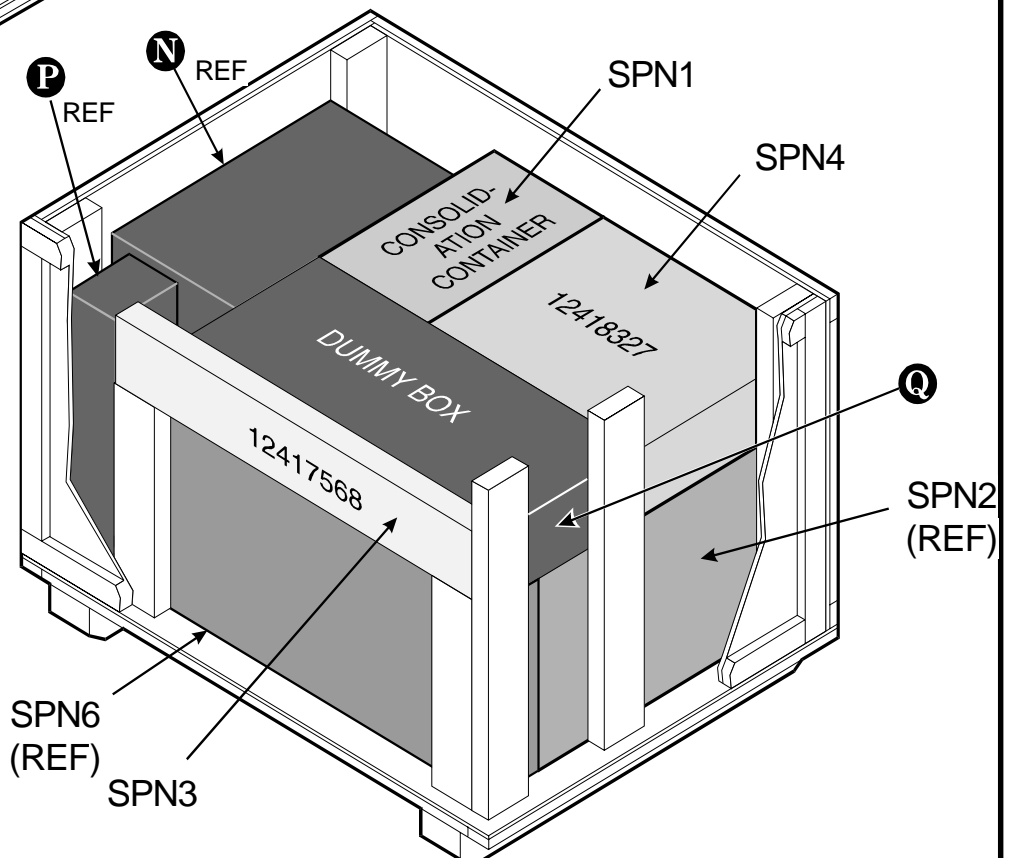
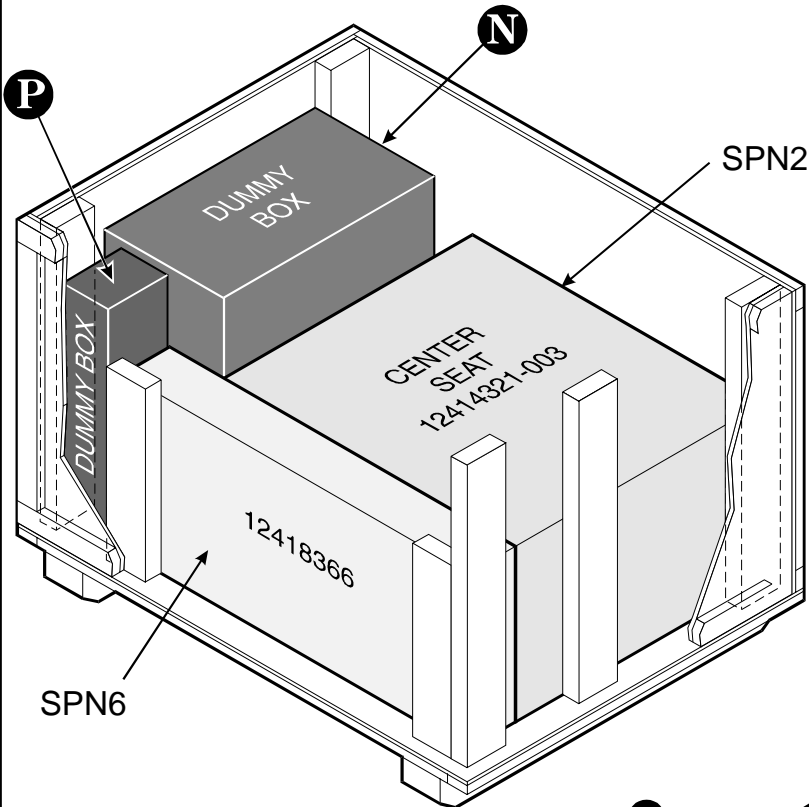
1005-01-381-5431

5. DATE OF DRAWING

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6. REVISION

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